

# Work Order ID 63723

November 11, 2010 8:27:34 AM

Page 1

Item ID: D212-725-1-055

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 11/11/10 Start Qty: 2.00

Cust Item ID:

Required Date: 11/12/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

Rev B/F 10.11.17

100

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg  
2- Drill holes as per dwg  
3-Make radius as pre dwg and deburr

*Handwritten notes:*  
10/11/15  
10/11/15  
M.L.

*Handwritten circled note:* 2X

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Handwritten note:* 8/10/16

*Handwritten circled note:* 2

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*Handwritten note:* 10/11/17

*Handwritten note:* 2

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Page 2

Item ID: D212-725-1-055

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 11/11/10 Start Qty: 2.00



Required Date: 11/12/10 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 10-11-17

140

Identify as per dwg & Stock Location: 386

0.00



Packaging

Memo

0.00

Packaging

10/11/17 (2)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/11/17  
BR 10-11-17  
(2)

# Picklist Print

November 11, 2010 8:27:33 AM

Page 1

Work Order ID: 63723

Parent Item: D212-725-1-055

Parent Item Name: Angle



Start Date: 11/11/10

Required Date: 11/12/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.10.28 as per dwg revF DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.250X1.0X. 063		Purchased	No				f	12.0000	0.7	1.4			X



2024T3511 ANGLE 1.250" X 1" X .063"W

Location

Loc Qty

Loc Code

MAT

12

116085

12



m-p 10/11/15

1.4

8 7 6 5 4 3 2 1

D

C

B

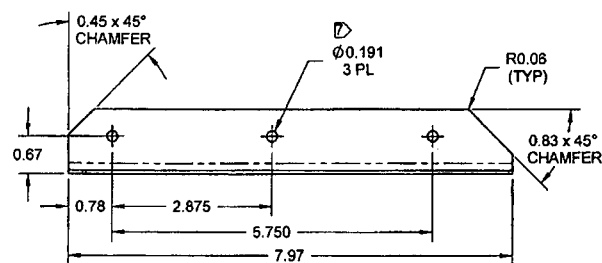
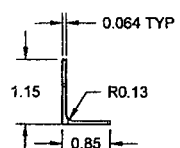
A

D

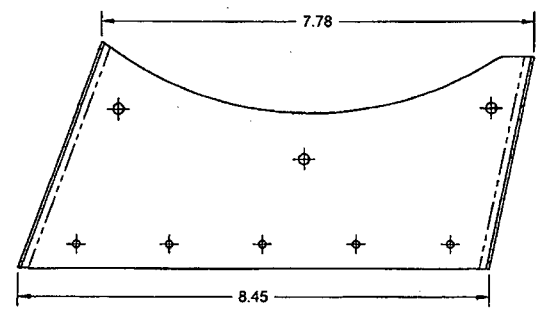
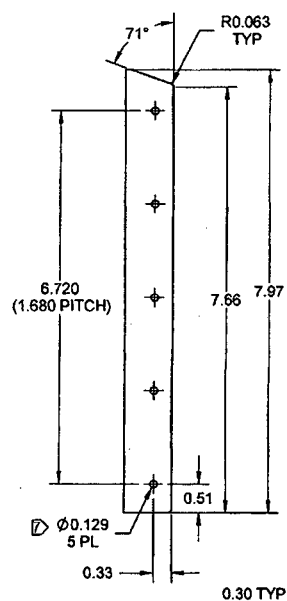
C

B

A



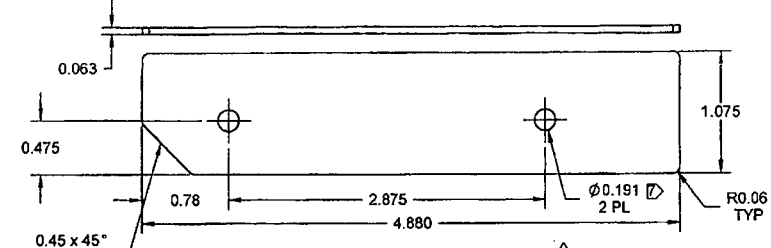
**D212-725-1-055 ANGLE**   
MATERIAL: 2024-T3511 (QQ-A-200/3F) ANGLE EXTRUSION  
(REF. DART SPEC. M2024T3-A)



**D212-725-1-057 SUPPORT BRACKET**   
(MAKE FROM D212-725-1-057F FLAT PATTERN)  
MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4  
(REF. DART SPEC. M2024T3S.050)

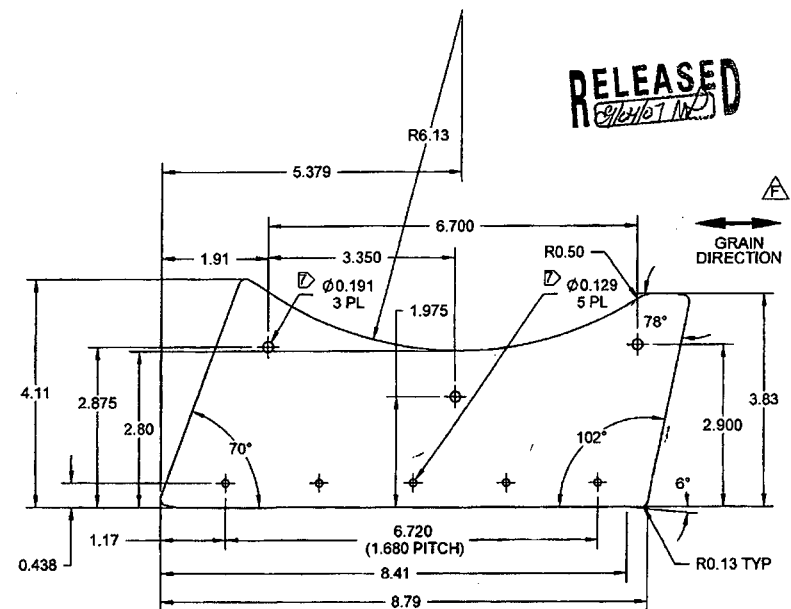
**GENERAL NOTES:**

- 1) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT IN ACCORDANCE WITH AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: N/A
- 7) DIMENSIONS BETWEEN HOLES ARE PROVIDED FOR REFERENCE ONLY, TRANSFER Ø0.129, Ø0.191 HOLES FROM AIRCRAFT






**D212-725-1-059 PACKER**   
MATERIAL: 2024-T3 SHEET 0.063 THICK PER QQ-A-250/4  
(REF. DART SPEC. M2024T3S.063)

**RELEASED**  
9/12/07 N2



**D212-725-1-057F FLAT PATTERN**

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		<b>D212-725-1</b>	SHEET 24 OF 84
APPROVED		TITLE	SCALE
DE APPR.		<b>212S DETAIL PARTS</b>	NTS
DATE	09.02.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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w/o 63723

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries